



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DAS
13
9-89

D3136-043
Job Sheet 175900



Part No: D3136-043

Job Qty: 3 ea

APR 17 2018

Part Name: Window Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/18/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV F IPP Rev:A 04.02.04 New issue KJ/DS IPP Rev.B 07.05.29 Thermoform in-house DL IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D 10.06.24 added note in qc5 seq 170 DD verf:EC IPP Rev E 14/01/20 Replace "Folio" with Work Instruction DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	3 pcs		4/18/18	0.00	0.00	Purchasing		APR 18 2018
140	Packaging	3 pcs		4/18/18	0.00	0.00	Packaging2		APR 18 2018
150	QC	3 pcs		4/18/18	0.00	0.00	QC6		APR 17 2018
170	Packaging	3 pcs		4/18/18	0.00	0.00	Packaging3-1		APR 17 2018
180	QC21-SA	3 Ea		4/18/18	0.00	0.00	QC21		APR 17 2018

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

P10: 39458

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APR 11 2018
APR 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3136-043P	Window Assembly	3 pcs (1 ea)	110-Purchasing	5061637
MACRLICS.125	1/8" Polycast li Sheet	11.7000 sf (3.9 ea)	110-Purchasing	5061637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3136-043P	3	0	0
	MACRLICS.125	12	2,055	0

Part Specifications

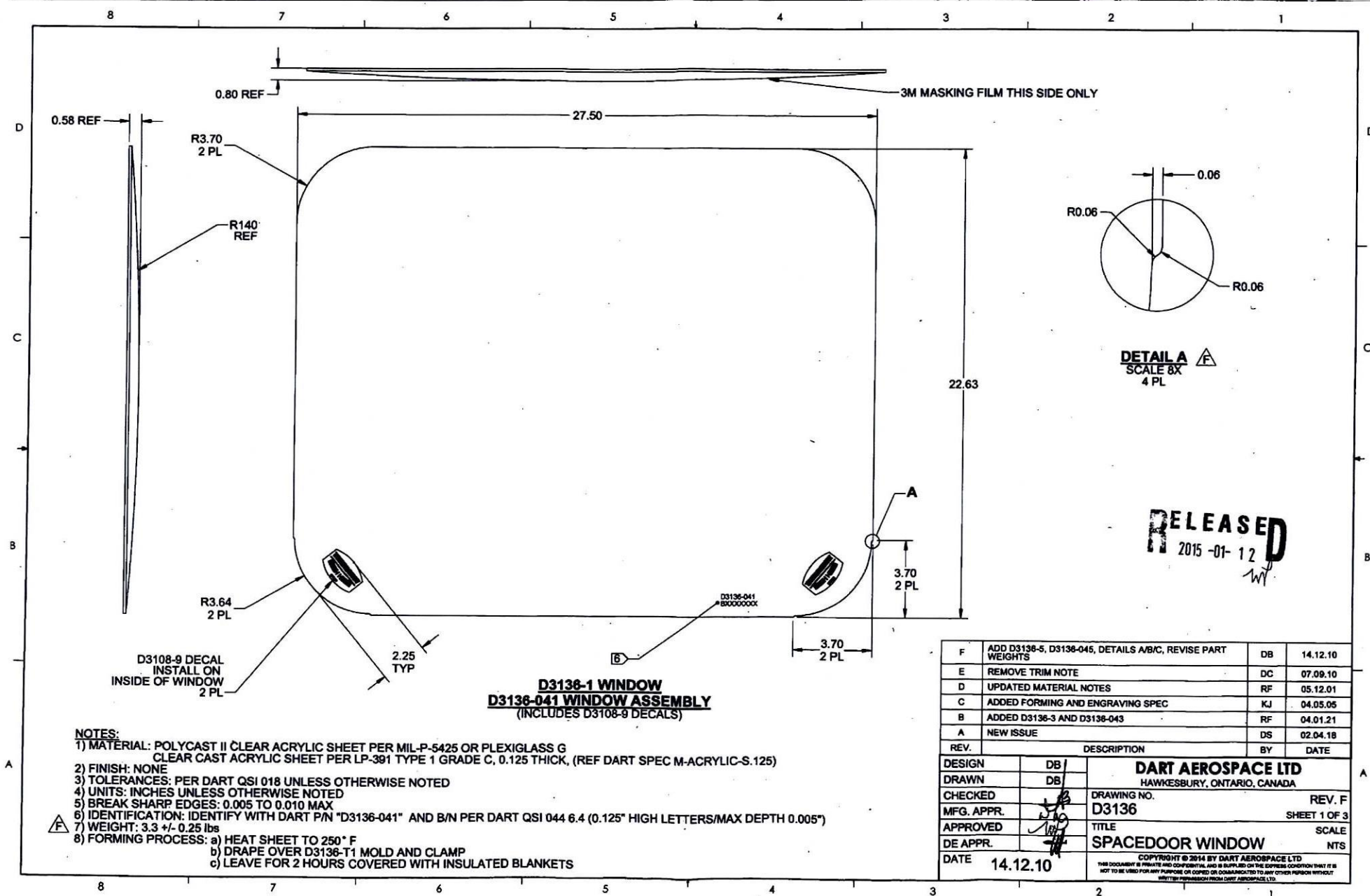
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Assembly	21.000Inches ± 0.030	21.030 20.970		
2	Window Assembly	25.750Inches ± 0.030	25.780 25.720		
3	Window Assembly	26.250Inches ± 0.030	26.280 26.220		

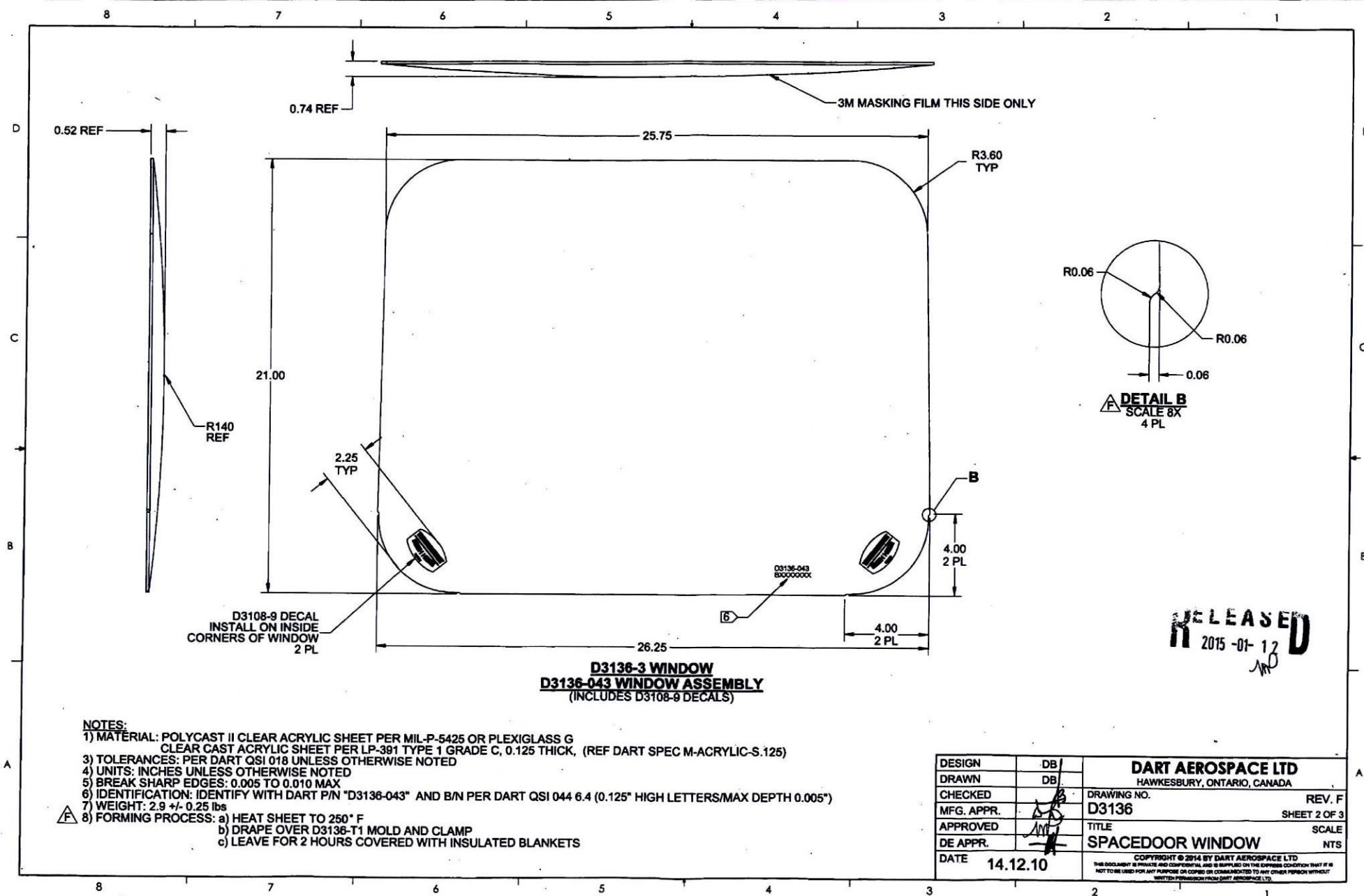
Plex 4/11/18 3:20 PM dart.lavoie.chantal

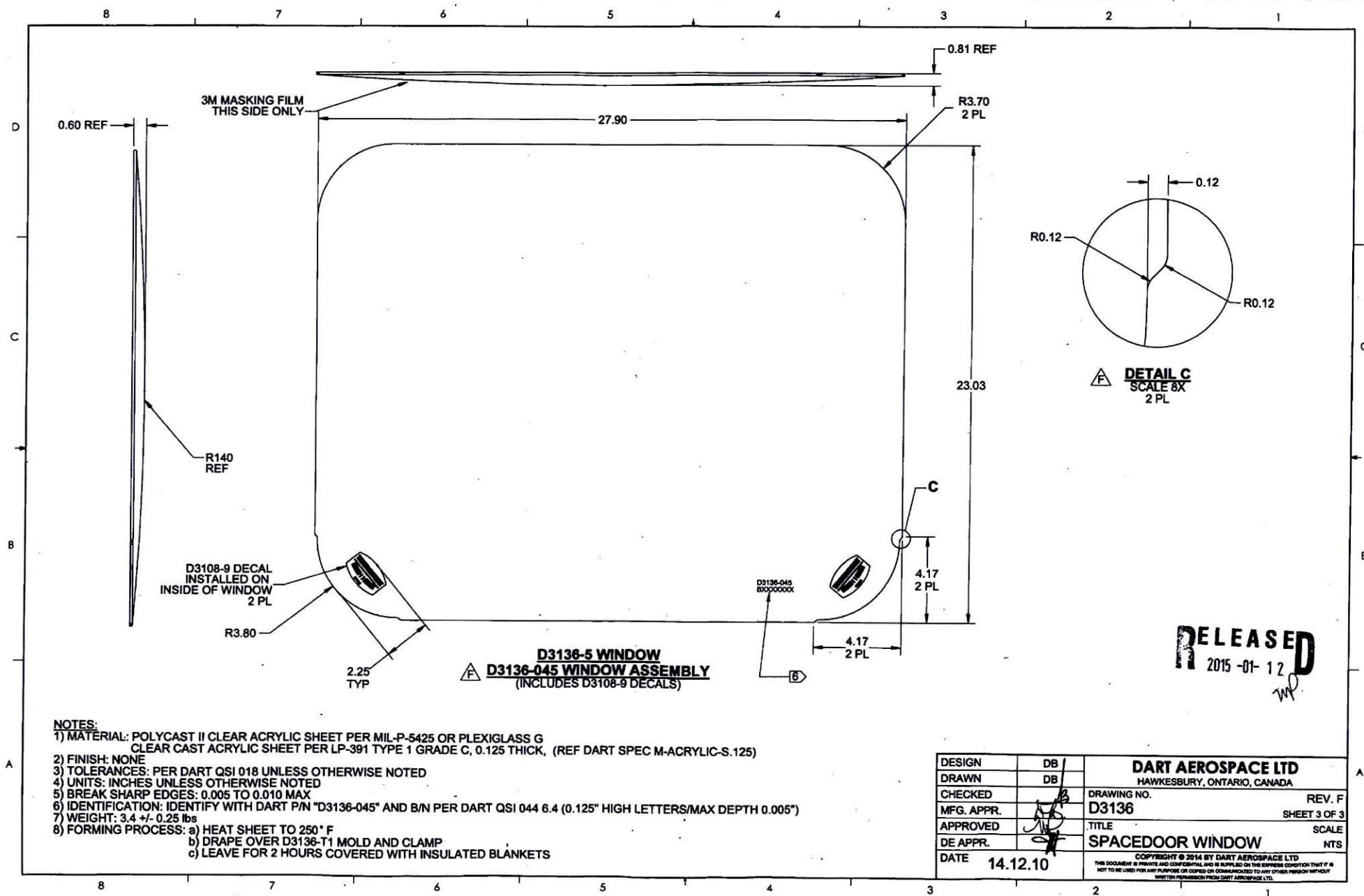


PART NO: D3136 - 043
Serial No/Batch: S061643
Revision:
Operation:
Change No: Packaging

Mfg Date: 04/17/18
Job No: 175900







NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-045" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
- 7) WEIGHT: 3.4 +/- 0.25 lbs
- 8) FORMING PROCESS: a) HEAT SHEET TO 250° F
 b) DRAPE OVER D3136-T1 MOLD AND CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.		D3136	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039458**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO039458

PO Date: 3/29/18

Due Date: 4/27/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

REUSE

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3875-1L08P			Floor Protector - Passenger Clear	Firmed	4/27/18	6 pcs	0 pcs	6 pcs	\$169.00/pcs	\$1,014.00
Line Item Note job no. 175160											
3	D3136-043P			Window Assembly receive pcs wo 176109	Firmed	4/23/18	2 pcs	0 pcs	2 pcs	\$100.00/pcs	\$200.00
				wo 175900	Firmed	4/27/18	1 pcs	0 pcs	1 pcs	\$100.00/pcs	\$100.00
Sub Total:							3	0	3		\$300.00

Grand Total: \$1,314.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL

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11/11/18

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 39458 SO # 023084

Part #	<u>D3136-043 (D3136-3)</u>	Qty.	<u>1</u>	Batch #	<u>-001</u>
Description	<u>SPACEDOOR WINDOW</u>	Material usage	<u>OFF CUT / STOCK</u>	Lot#	<u>240394</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS

(Approved QA Signatory)

Date: APRIL 12, 2018

C O F C # 056

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Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com